

5/46

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	24677
<b>Description:</b> Bracket Assembly	<b>Part Number:</b>	D3121-041
<b>Dwg:</b> D3121 Rev. C2 page 1, 3, 4	<b>Qty:</b>	10 Kits
D3121-041 replaces Premier P/N B30-23000-33		
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Dwg not required</b>	KJ	05.10.26	10
2	MV	Cut blank: 1.00" x 2.00" x 3.250" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B1.000x02.000) Batch: <u>M14773</u> <b>Identify for D3121-11</b>	J.L	05.11.14	10
3	MV	Machine as per Folio FA331 and Dwg D3121 <b>Identify as D3121-11</b>	BG/J.L	05.11.20	10
4	QC2	Inspect parts as they come off the CNC machine	BG/J.L	05.11.20	10
5	MV	Deburr. Break all sharp edges 0.005 to 0.015	BG/J.L	05.11.20	10
6	MV	Scribe batch number to D3121-11 at the back face.	BG	05.11.20	10
7	QC8	Second check of D3121-11	En	06/02/03	10
8	GA	Assemble D3121-041 as per Dwg D3121 <b>Pick:</b> Qty Part Number Description Batch 1 D3121-21 Bolt B244750B 1 D3121-241 Bearing Assy B24777	En	06/02/03	10
9	QC5	Inspect work to Step 8	2	06.02.03	10
10	ST	Identify and Stock in Spacedoor cell C.A.S	CR	06/02/06	10
11	AC	Cost / part: _____	Sut	06.02.07	10
12	DC	Close W/O Inspect Level 21	D	06/02/07	10

Rev	Date	Change	Revised By	Approved
A	02.05.21	New issue	NG	
B	03.05.02	Reformat	KJ/RF	
C	05.06.09	Hardware revised in Step 8	KJ/JLM	

**RELEASED**  
05/16/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 06/02/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

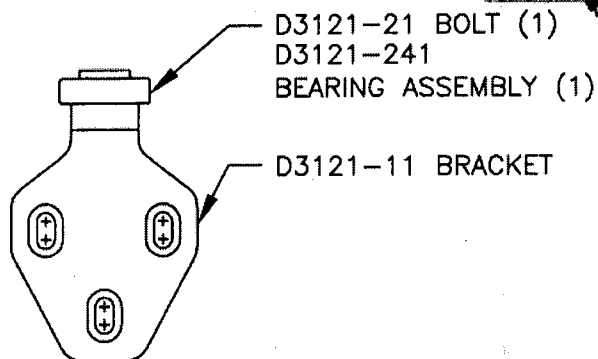
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05.11.18	3	- 1 part spigot $\phi$ is too small of .002 - $\phi$ is .390 instead of .392	<i>[Signature]</i>	- scrap + replace	J.L. 05.11.18	2 06.02.03	<i>[Signature]</i>	2 06.02.03
05.11.21	3	Part came out of vise. Deep scoring	<i>[Signature]</i>	- scrap + replace	BG			

NOTE: Date & initial all entries

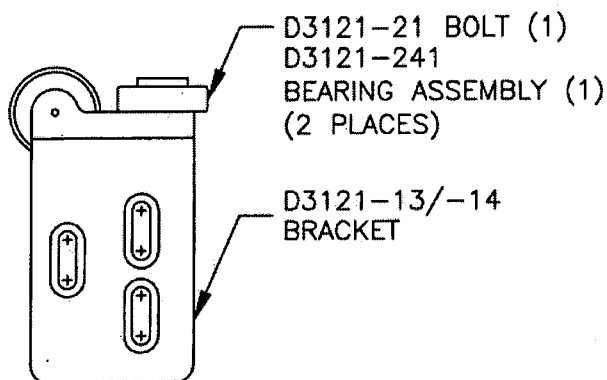


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 1 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
C1	CP # 04.03.26	3.97 WAS 4.00; 6.11 WAS 6.14	
C2	# 04.04.26	0.230 WAS 0.238	

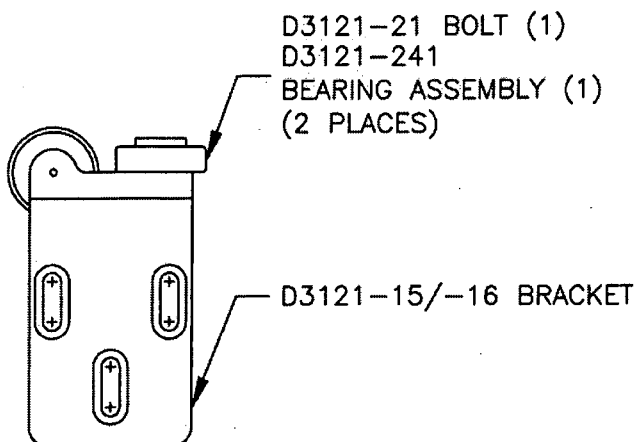
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04.03.01 #



**D3121-041 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-33)



**D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-37/-38)



**D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-35/-36)

ENGINEERING

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WORK ORDER

NO. 24677

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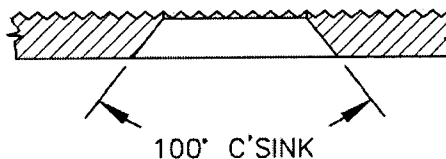
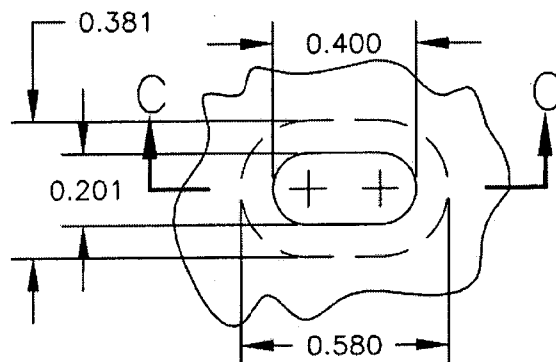
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. C SHEET 3 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1

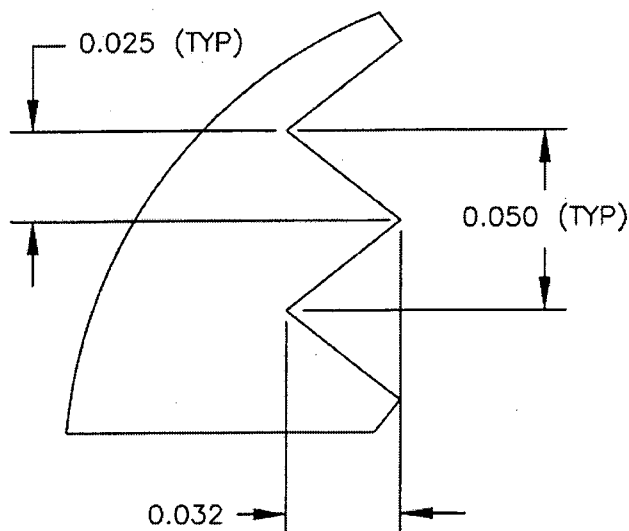
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04.03.01 #

**DETAIL A:**  
**SLOT DETAIL**  
SCALE 2:1  
VIEW ROTATED



**SECTION**  
**C-C**

**DETAIL B:**  
**RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20



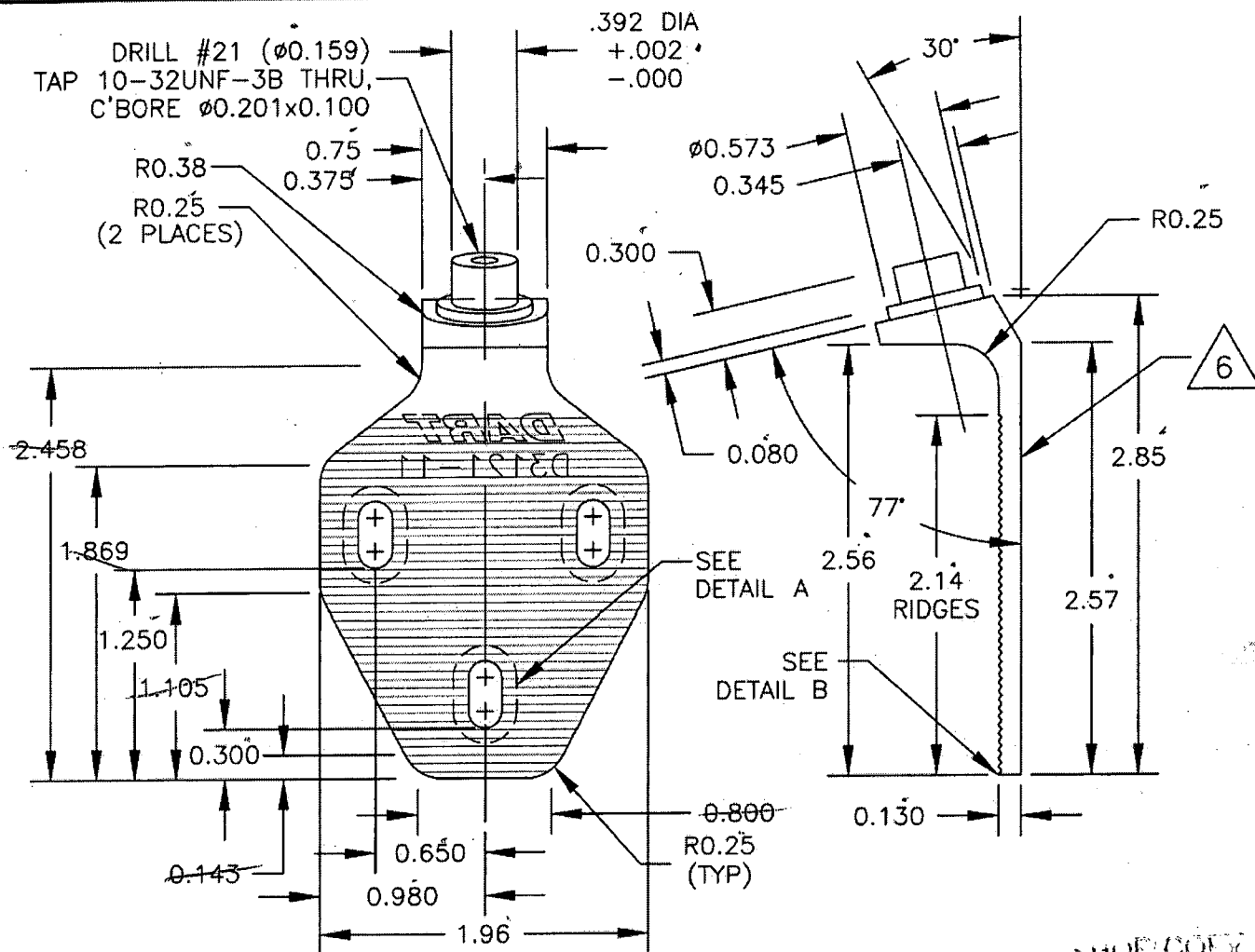
WORK ORDER  
NO. 24677

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3121	REV. C SHEET 4 OF 10
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



#### D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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WORK ORDER

24677

RELEASED  
04.03.01

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 25, 2005  
04:04 pm

Work Order No : 0024677  
Project Name : D3121-041  
Project For : WK546  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3121-041  
Description : Bracket Assembly  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 10-25-05  
Est Finish Date : 11-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Mark Up : 0.000%  
Actual Mark Up : 0.000%  
\$0 Posted to Finished Goods

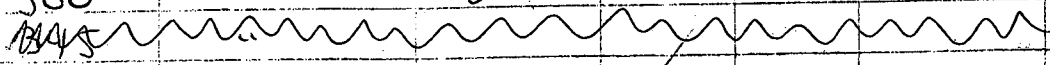
	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 24677
Description: bracket assembly		Part Number: D3121-11
Inspection Dwg: D3121	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 392	+ .002 - .001	392	✓			
Ø 201 X .100	+ .010	202 X .097	✓			
.750	+ .030	.752	✓			
.375	+ .010	.374	✓			
1.960	+ .030	1.961	✓			
1.250	+ .010	1.246	✓			
1.38	+ .030	.38	✓			
1.25	"	.25	✓			
.300	+ .010	.297	✓			
<del>.800</del>	<del>+ .001</del>					
1.25	+ .030	.250	✓			
.980	+ .010	.975	✓			
.650	"	.655	✓			
1.25	+ .03	.250	✓			
2.85	+ .030	2.851	✓			
2.57	"	2.580	✓			
.130	+ .010	.121	✓			
2.14	+ .030	2.145	✓			
2.56	"	2.555	✓			
.080	+ .010	.078	✓			
.300	"	.300	✓			
						
Ø 573	"	.570	✓			cap measure

Measured by: J.L.	Audited by: [Signature]	Prototype Approval:
Date: 05.11.18	Date: 05/11/18	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	